

Date: Tuesday, 1/16/2007 7:09:52 AM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 30254		
Estimate Number	: 11136		
P.O. Number	: N/A	Part Number	: D3183045
This Issue	: 1/16/2007	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Number	: D3183 REV C1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30004	Drawing Revision	: C1
Written By	:	Material	: N/A
Checked & Approved By	:	Due Date	: 1/23/2007
Comment	: Est A04.02.18 New issue KJ/DS	Qty:	40
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR1000	Delrin Round Bar 1"	
		D3183-9	
		Comment: Qty.: 0.0350 f(s)/Unit Total : 1.3986 f(s) Delrin Round Bar 1" Material: Ø1.00 Delrin Rod (M-DELRIN-R1.000) Identify as D3183-9 Batch: B28705	and 07/01/16 40
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn D3183-9 Cap as per Folio FA388 Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	D31835	Bearing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Qty Part Number Description Batch	 B29732 and 07/01/16 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BEARING ASSEMBLY

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Part Number: D3183045

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

*ML 07/01/16*

40

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*MS 07/01/16*

40

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*ML 07/01/16*

40

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*ML 07/01/16*

40

Job Completion



*ML 07/01/16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

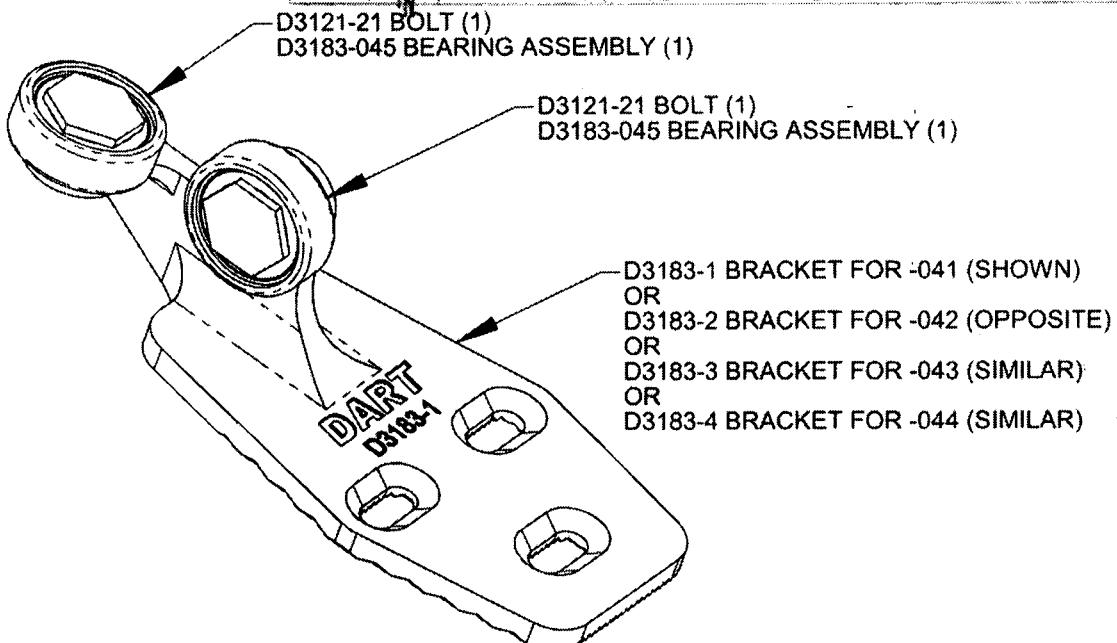
NOTE: Date & initial all entries



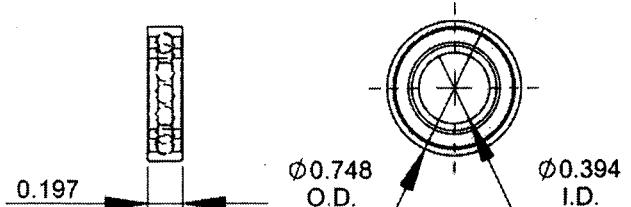
COPY ISSUED  
TO

DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED  
04.03.01 C1



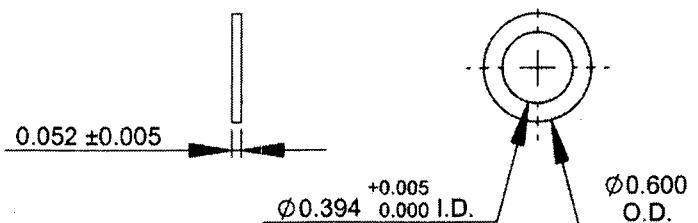
**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**



#### **D3183-5 BEARING: SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE,  
CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

#### **D3183-7 WASHER**



- 1) MATERIAL: AISI 303 ROUND BAR (M303R)  
ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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07/01/16  
w/o 30254

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D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE

**1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4**

**2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)**

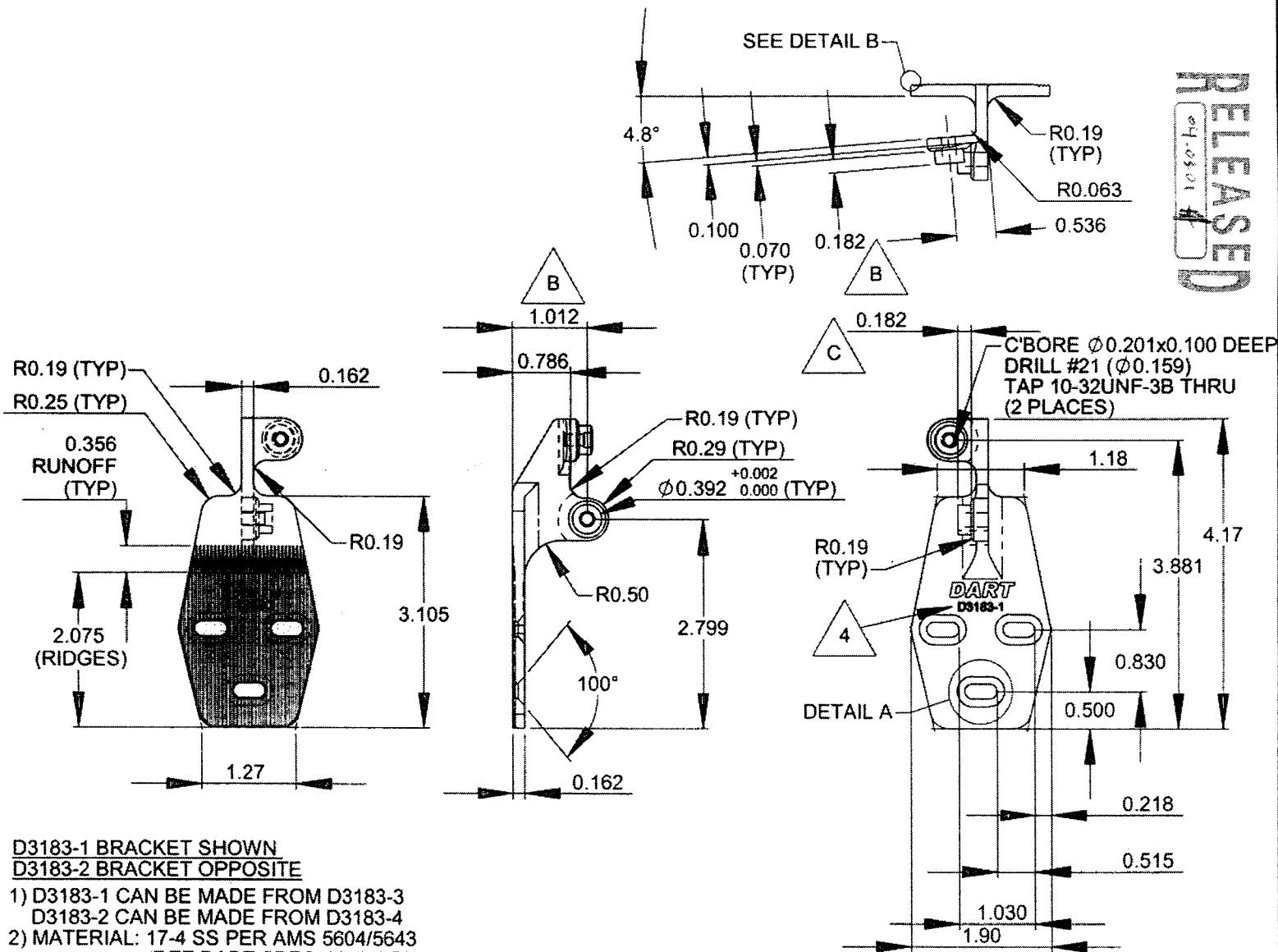
**MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi**

**3) BREAK ALL SHARP EDGES 0.005 TO 0.015**

**4) ENGRAVE DART P/N & LOGO AS SHOWN**

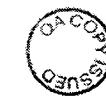
**5) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED**

**6) ALL DIMENSIONS ARE IN INCHES**

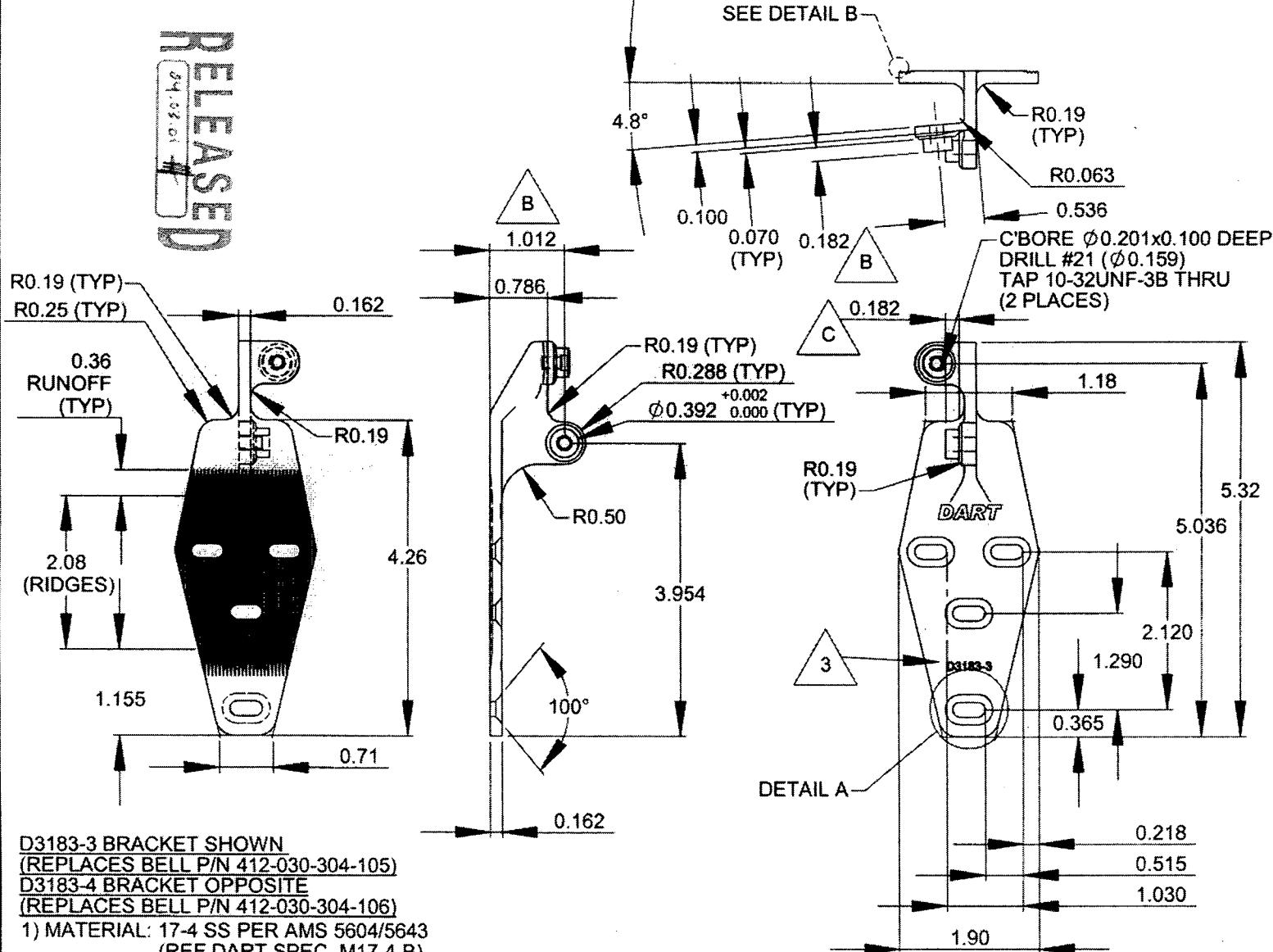


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	SHEET 2 OF 4	REV. C
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:2		

**DART**



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		REV. C
		SHEET 3 OF 4
		SCALE 1:2



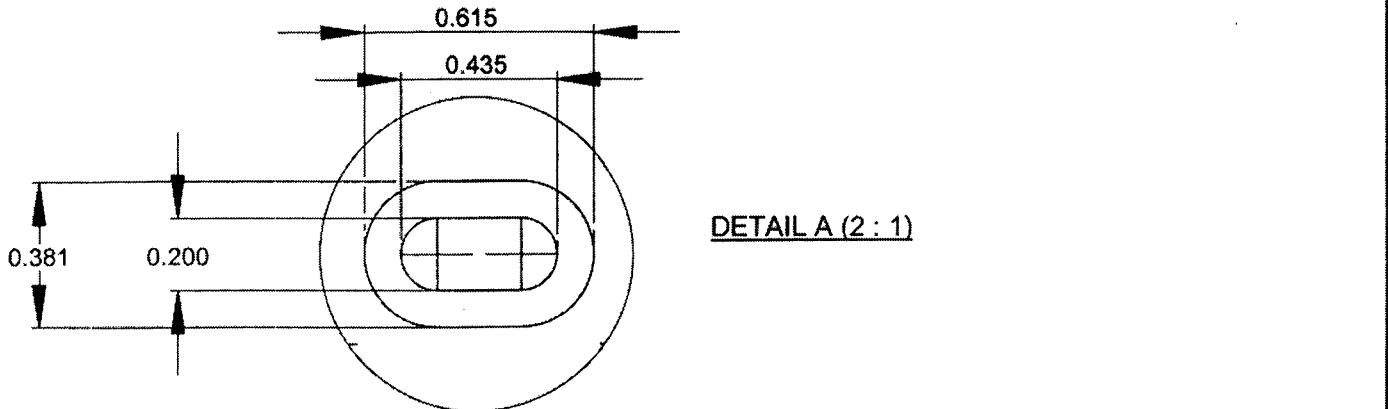
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207/01/16  
W/O 30254



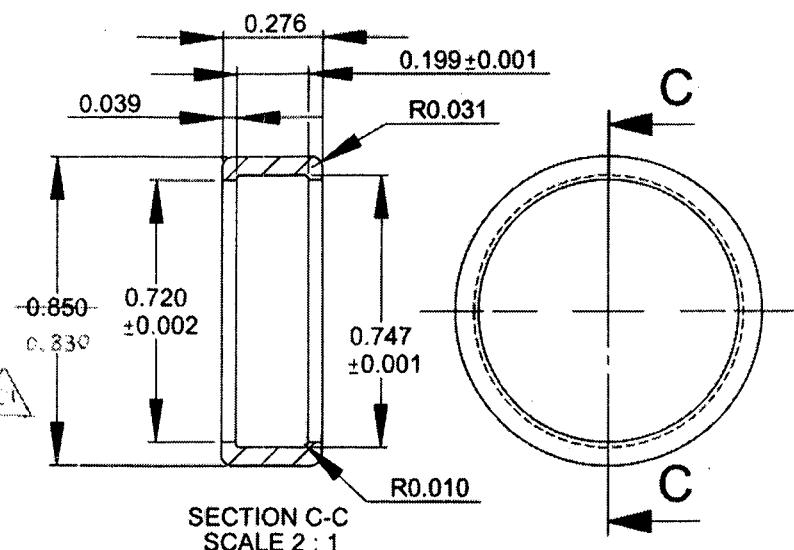
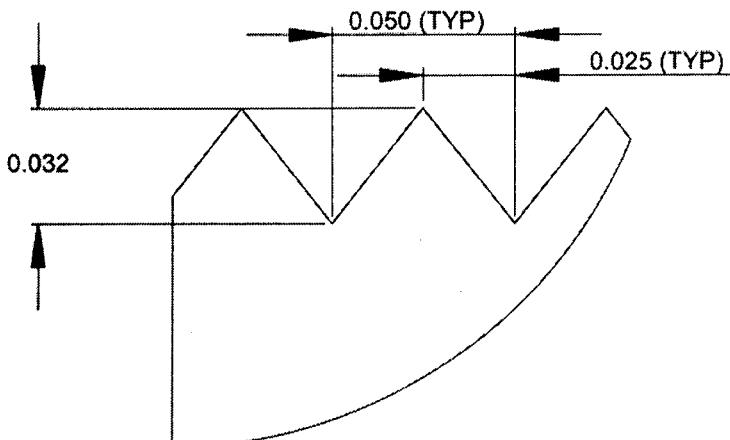
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CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	04.02.17	TITLE	SHEET 4 OF 4 SCALE 1:1



DETAIL A (2 : 1)

**RELEASED**  
04.03.01

DETAIL B (20 : 1)



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP



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